

Work Order ID 126357***126357***

Page 1

Wednesday, November 05, 2014 7:47:37 AM

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Body RH
Start Date: 11/5/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/5/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 11-11-05 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3188	G

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 26420

Description: D3188-2MBODY

SHIP: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

CX 14/11/07 ①

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

1X 5015-03-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Wednesday, November 05, 2014 7:47:37 AM

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Revision ID: Stop ***NS2***
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Required Date: 11/5/2014 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								15-03-10
130	Identify as per dwg & Stock Location: <u>CA2</u>	0.00							
130									
Packaging	Memo	0.00							15-03-10
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							15-03-10
Quality Control									

15-03-10

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, November 05, 2014 7:47:41 AM

Page 1

Work Order ID: 126357

126357

Parent Item: D3188-2M

D3188-2M

Parent Item Name: Spacepod Body RH

Start Date: 11/5/2014

Required Date: 11/5/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP Rev:A	New issue ecn882	06-11-30	EC
	IPP rev B	rev D dwg	07.03.07	ec
	IPP rev C	rev E dwg	07.04.16	EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213		Manufactured	No			100	Each	66.0000	8	8			
D2213 Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST004		66							
				30809		66							
D3188-2P		Purchased	No			110	Each	0.0000	1	1			
D3188-2P Spacepod Body													

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYLCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

10) POT INSERTS PER QSI 006 SECTION 4.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

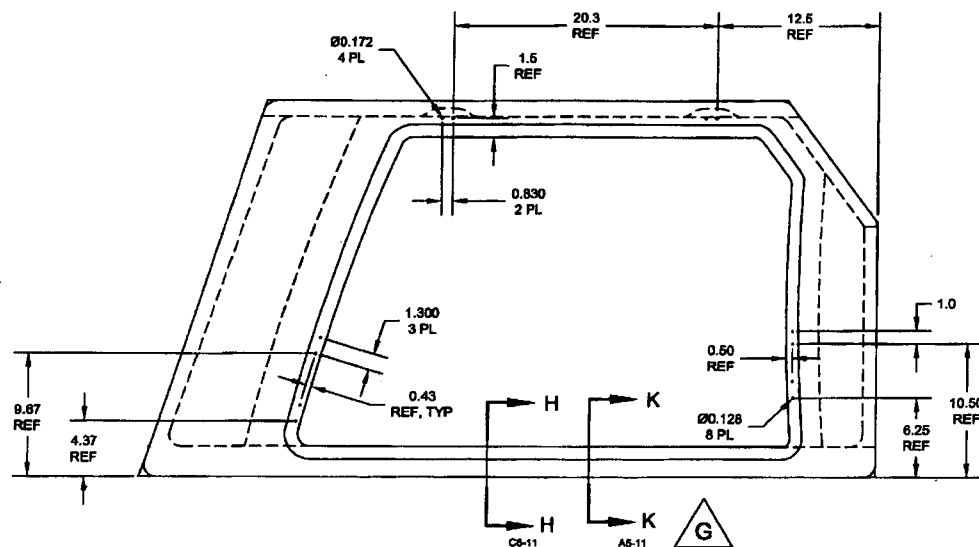
WITHOUT NOTICE
WORK ORDER

NO 126357 MW

14-11-05

RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT, INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.08.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	08.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	08.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



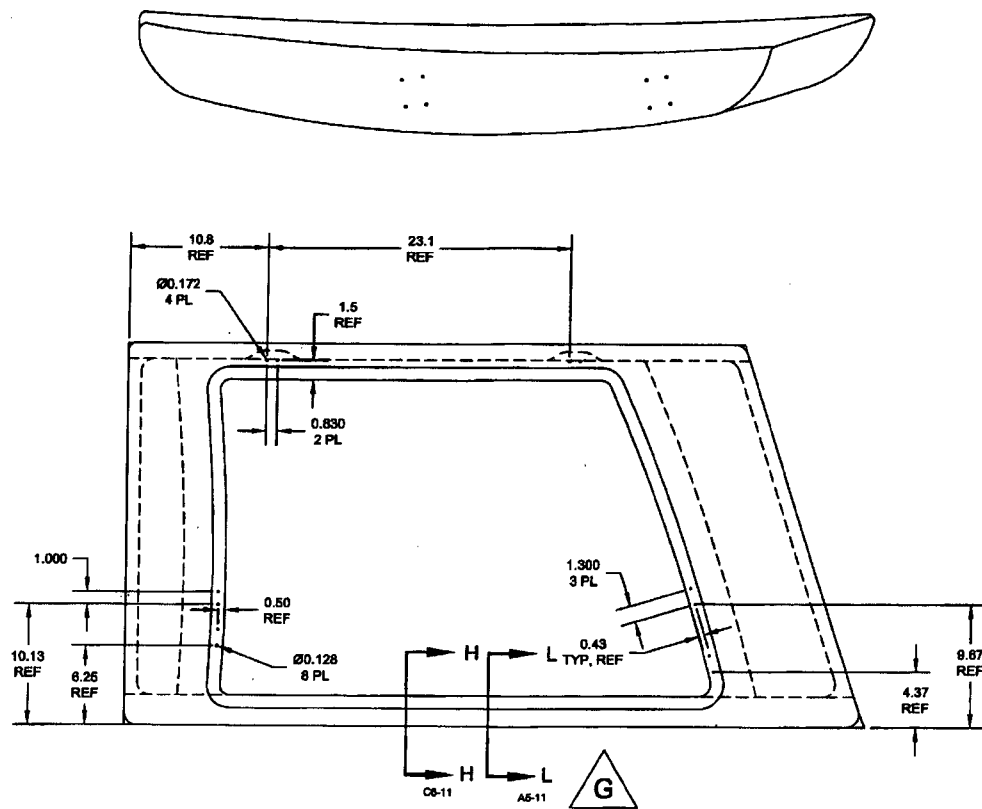
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

RELEASED
2014-07-28

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 2 OF 11
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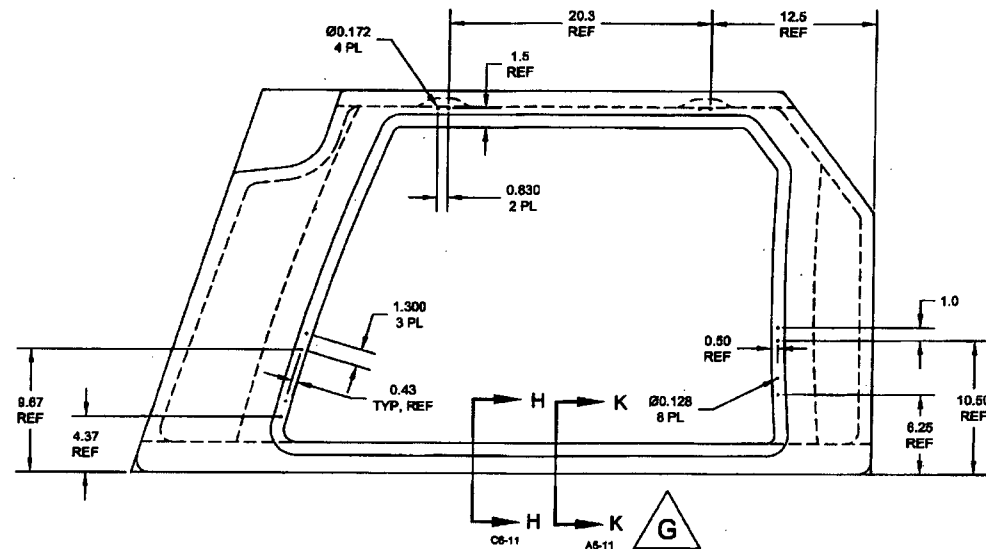
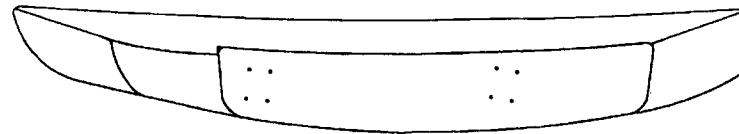
D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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2014-07-28

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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 3 OF 11
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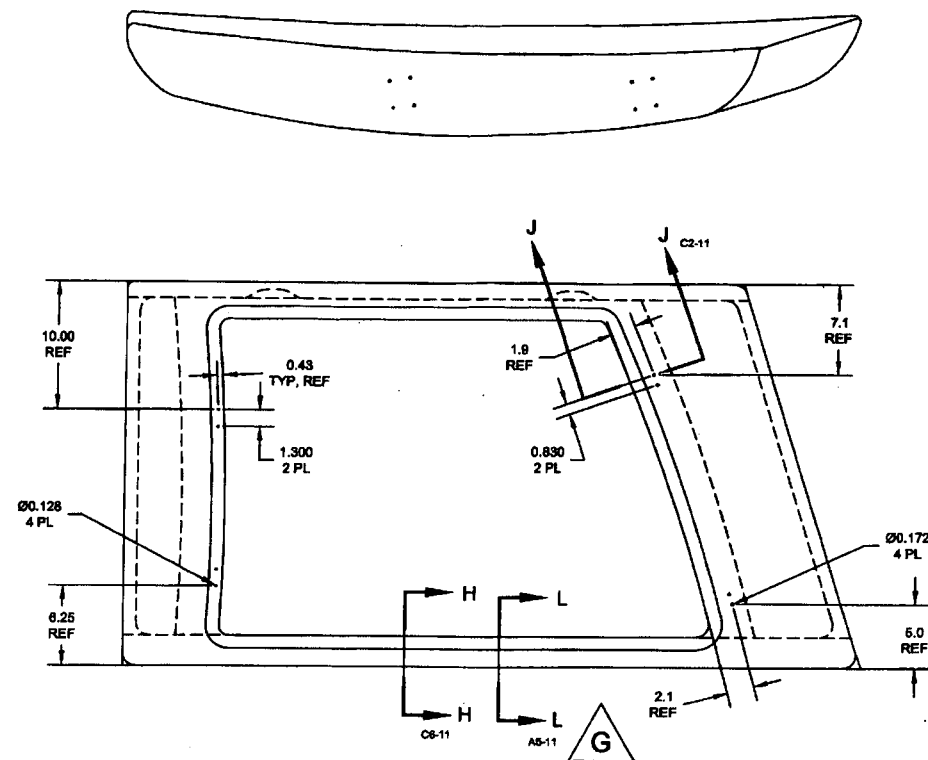
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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2014-07-28

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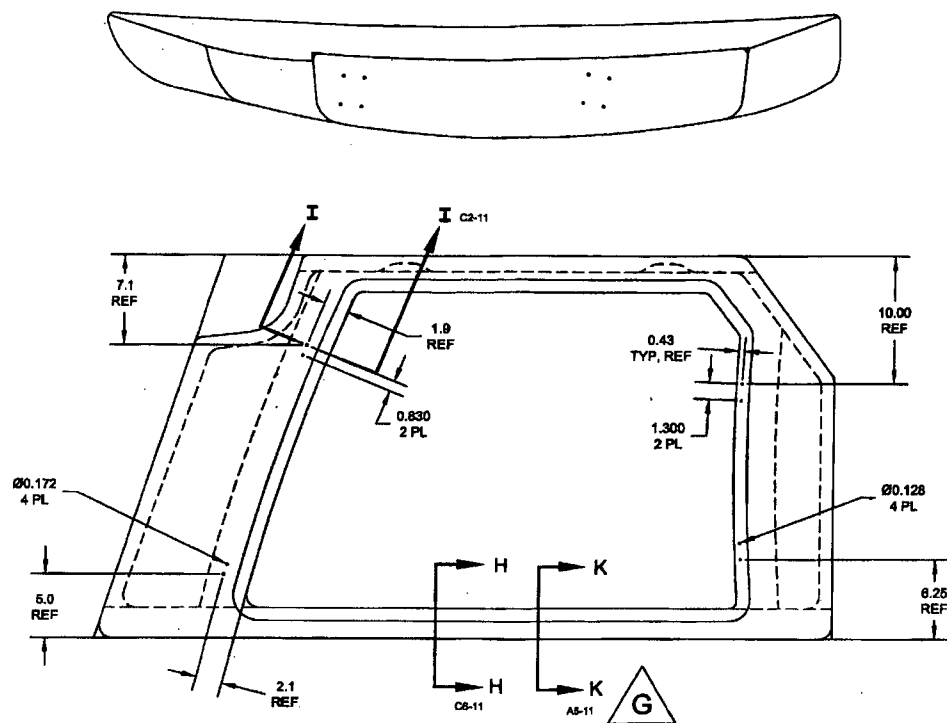
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.		D3188	SHEET 8 OF 11
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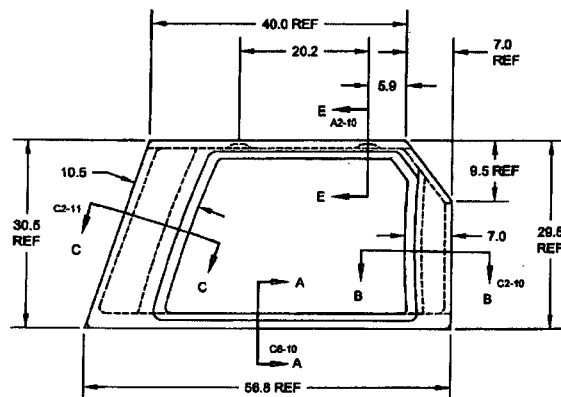
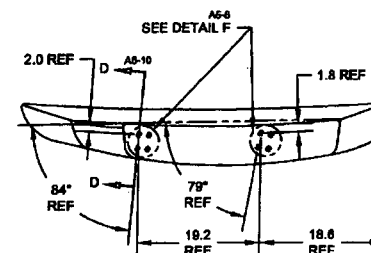
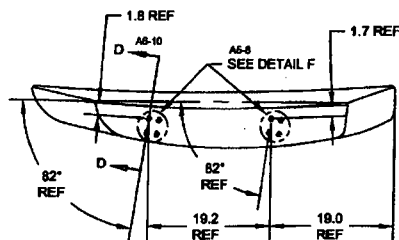
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

RELEASED
2014-07-28
JW

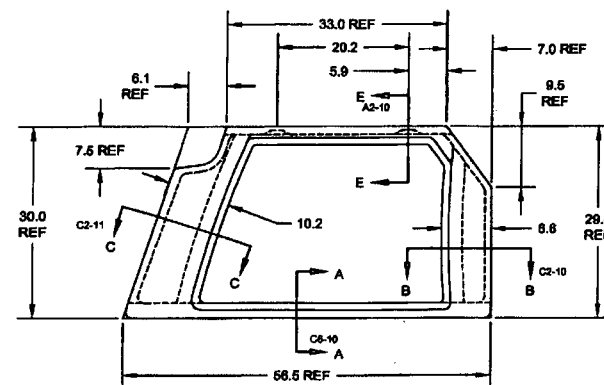
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

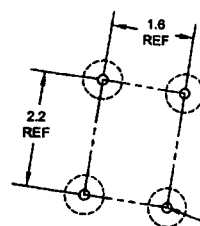
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D3188	SHEET 7 OF 11
APPROVED	JB	TITLE	SCALE
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

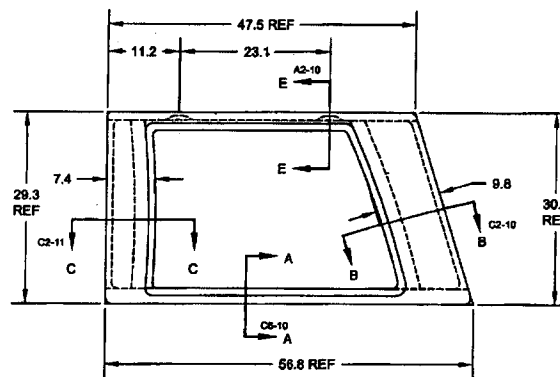
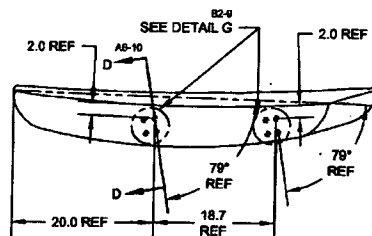
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3188-1M/3M NOTES:

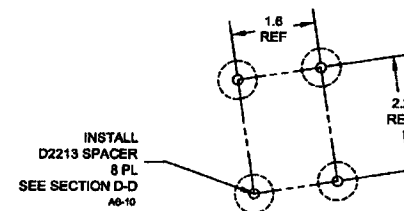
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2014-07-28

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D3186-2M SPACEPOD BODY



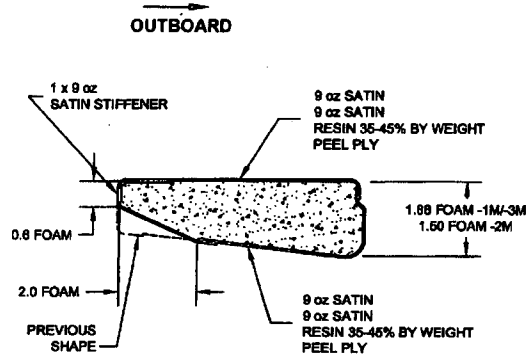
DETAIL G D6-9

RELEASED
2014-07-28

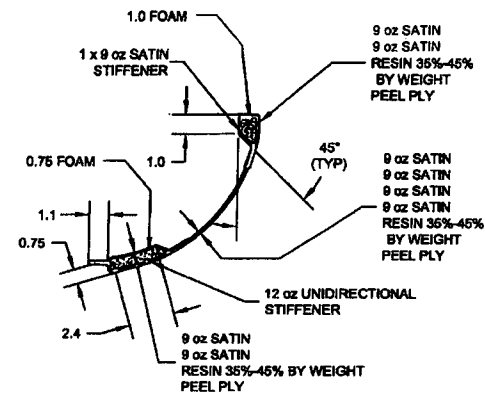
D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

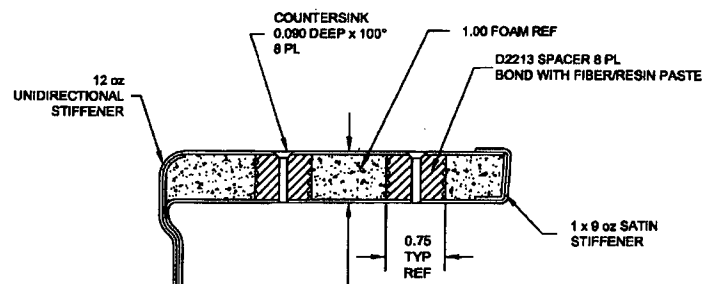
DESIGN	JB	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



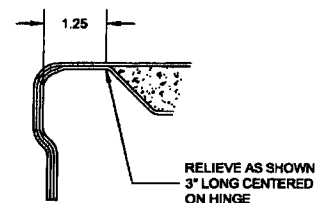
SECTION A-A
TYPICAL FLOOR SECTION



SECTION B-B
SECTION C-C OPPOSITE



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS



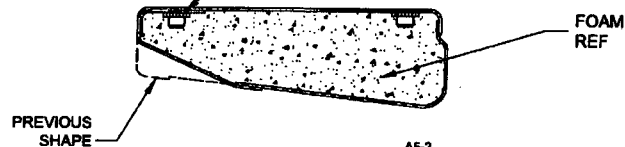
SECTION E-E
2 PLACES PER POD

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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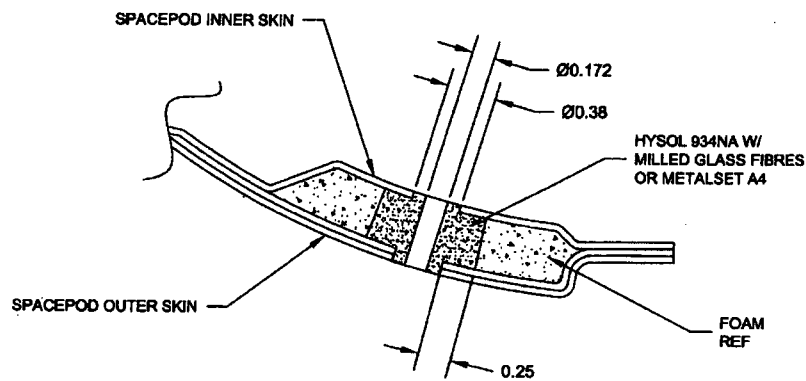
OUTBOARD

INSTALL AKS7-1032-130
INSERTS 28 PL
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)
TO ALIGN WITH HOLES IN D3187-1/-2 FLOORS



SECTION H-H
TYPICAL FLOOR SECTION

A5-2
A5-3
A5-4
A5-6
B5-6
B5-7



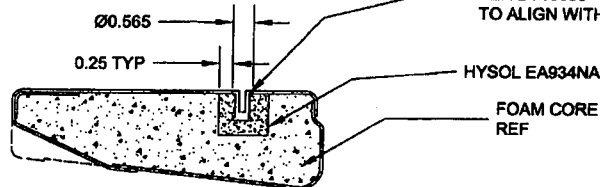
SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C6-7

OUTBOARD

10

INSTALL 80-005-2-10
INSERTS 7 PL
PER DT10068
TO ALIGN WITH HOLES IN D3187-1/-2 FLOORS



SECTION K-K
SECTION L-L OPPOSITE
TYPICAL FLOOR SECTION

B4-2
B4-3
B4-4
B4-5
B4-6
B4-7

RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26420**

Purchase Order Date 11/7/2014

PO Print Date 11/7/2014

Page Number 1 of 2

Order From :
DELASTEK INC
2699 SE AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 533 5788

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

*REVISED
date.*

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3186-2P MAKE AS PER DWG D3186 REV.E B126355	Spacepod Door	12/12/2014 Yes 12/12/2014 <i>2/27/2015</i>		1.00 Each	\$726.64	\$726.64
Line Total:							\$726.64
2	D3188-2P ✓ MAKE AS PER DWG D 3188 REV.G B126357	Spacepod Body	12/12/2014 Yes 12/12/2014 <i>2/27/2015</i>		1.00 ✓ Each	\$2,224.89	\$2,224.89
Line Total:							\$2,224.89
3	D3186-2P MAKE AS PER DWG D3186 REV.E B126354	Spacepod Door	12/12/2014 Yes 12/12/2014 <i>2/27</i>		1.00 Each	\$726.64	\$726.64

SP15-3-5.

Note:

11/7/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	59512
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Contact : D.Bates

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-03-2015	20-11-2014	25217	Chantal Lavoie	PO26420	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Fedex Freight LTL Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0060	Line 1 N° D3186-2M Spacepod Door RH B1263 U of M: Chaque Dwg. D3186 Rév.: E Serial # 66241 Lot # 66241	
1	0	1	DKC134-0071	Line 2 N° D3188-2M, Spacepod Body RH B1263 U of M: Chaque Dwg. D3188 Rév.: G Serial # 66243 Lot # 66243	
1	0	1	DKC134-0060	Line 3 N° D3186-2M Spacepod Door RH B1263 U of M: Chaque Dwg. D3186 Rév.: E Serial # 66242 Lot # 66242	
1	0	1	DKC134-0071	Line 4 N° D3188-2M, Spacepod Body RH B1263 U of M: Chaque Dwg. D3188 Rév.: G Serial # 66244 Lot # 66244	
				DOCUMENT INCLUS	39

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

[Signature]

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2015-01-06 13:39:24
Utilisateur: marc dubé

Feuille de Procédé

9/12jan

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD BODY RH
Numéro Job	: 66243	Numéro Article	: DKC134-0071
Numéro Soumission	: 3763	Numéro Dessin	: -
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2015-01-06 No. B.V. :	Révision dessin	:
Prsht Rev.	: NC	Matériel	: Fibre 7781 et résine 411-350
Prem. fois	: - - Type :	Date Dûe	: 2015-02-16 Qté: 1 Udm: UNITE
Job précédente	: 66079		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de dessin: D3188-2M rev. G		



E.O.: N/A

Feuille de Procédé Rév.: 07 Dessin passe de la révision F à G (réf. RFC #501)

Formulaire d'inspection: N/A

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo N° de Lot: 4802810AA

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: 29/01/15 Sceau: 56

3.0 AAC1885 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

4.0 AAC1887 Wrightlon 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

Date: Mardi, 2015-01-06 13:39:24
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD
Numéro Job: 66243

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	AC0943	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 11.40 VERGE(s)/Unit Total : 11.40 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-49418-1

8.0	AMB0511	N° TG-13-U, Fiberglass 13 oz
-----	---------	------------------------------

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

9.0	AMB0213	WR1850 Roving 18oz. x 50"
-----	---------	---------------------------

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-35539-1

10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 29/01/15 Sceau:



4102 N.T

12.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 4925810 AA

14.0	AAC1540	Fibre de verre Miapoxy 66
------	---------	---------------------------

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-49418-3

15.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 29/01/15 Sceau:



4102 N.T

Date: Mardi, 2015-01-06 13:39:25
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 66243

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

16.0

AMB0355

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick

N° de Lot:

1-43145-1

17.0

TAILLAGE

Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 3/6/15 Sceau:



4102 N.T

18.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.136 KILOGRAMME(s)/Unit Total : 0.136 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

4725810AA

19.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)
Catalyst N° DDM-9

N° de Lot:

1-27829-1

20.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 3/6/15 Sceau:



4102 N.T

21.0

PERCAGE

Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Perçer les foam core selon IF134-0020.

Date: 4/6/15 Sceau:



4102 N.T

22.0

AAC1611

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)
Polybond B46F

N° de Lot:

1-44904-1

23.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: Mardi, 2015-01-06 13:39:25

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 66243

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 4/02/15 Sceau:



4102 N.T

24.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 47955 20AA

25.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 4/02/15 Sceau:



26.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 4925810AA

27.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

28.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020

Date: 9/02/15 Sceau:



29.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022

Date: 10/02/15 Sceau:



30.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

31.0

AAC1540

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-44738-3

Date: Mardi, 2015-01-06 13:39:25

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 66243

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

32.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

4925810AA

33.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date:

11/02/15

Sceau:



34.0

AAC1610

Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total :

1 UNITE(s)

Spacer N° D2213

N° de Lot:

4867210AA

35.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date:

11/02/15

Sceau:



36.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total :

0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

4768450AA

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

4768410AA

38.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date:

12/02/15

Sceau:

4295.V

39.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date:

12/02/15

Sceau:

4232A

de fiche de mélange:

10611

Date: Mardi, 2015-01-06 13:39:25
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SPACEPOD BODY RH	
Numéro Job: 66243		Numéro Article: DKC134-0071	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
40.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>4295920AA</u>			
41.0	FINITION	Finition Générale	
 			
Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs Faire les réparations de finition s'il y a lieu selon IG 0008. Date: <u>13-02</u> Sceau: 			
42.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>			
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>NA</u>			
44.0	PRIMER	Application primer	
 			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>13/2/15</u> Sceau: <u>42358</u> # de fiche de mélange: <u>10613</u>			
45.0	INSPEC FINAL	Inspection finale	
 			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Faire l'inspection générale de la pièce selon le dessin par le département de la qualité. Date: <u>16/02/15</u> Sceau:  Initiales: <u>MA</u>			
46.0	EMBAL / ENTREPO	Emballage & Entreposage	
 			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'emballage selon IG 0057. Date: <u>17/2/15</u> Sceau: 			